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B23K 37/053**B23K 9/00****B23K 9/028****B23K 9/035****B23K 37/00**(21) Application number: **06334325**(71) Applicant: **OMI TADAHIRO**(22) Date of filing: **16.12.94**(72) Inventor: **OMI TADAHIRO**(54) **PRECISE WELDING METHOD FOR SUPPLYING
FLUID AND WELDING JIG**

(57) Abstract

PURPOSE: To provide a fluid supplying precise welding method and a jig therefor which prevent the reduction of inside pressure of B.S.G. at the time of welding with a simple composition.

CONSTITUTION: Respective end parts 21a, 22a to be welded of tubes 21, 22 are fixed temporarily with tube fixing vises 7, 8 to one side frame 1 and the other side frame 2 to be fixed with bolts 11, 12. The right and left tubes 21, 22 to be welded to a welding jig 10 are adjusted so that the cross sectional circles of the tube end parts 21a, 22a are made to the same center at the almost central part of the welding jig and the tubes 21, 22 are made on a straight line. In this state, nuts 5, 6 are tightened, the tension is applied between the frames, and a prescribed pressing force is applied between mutual right and left end faces 21a, 22a of the tubes. Due to this pressing force, the generation of the clearance at the time of welding and the gas leak of B.S.G. are prevented.

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